

Work Order ID 62724

Wednesday, October 06, 2010 3:58:40 PM

Page 1

Item ID: D3200-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Post Block

Start Date: 10/6/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 11/1/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3200

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.700" x 2.700

B.A 10/11/01

20

Ø

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3200-1 as per Folio FA337 and Dwg D3200-2-Deburr

B.A 10/11/02

20

Ø

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 10/11/02

20

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 10/6/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 11/1/2010 Req'd Qty: 20.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				20	0		
140  Packaging Packaging	Identify as per dwg & Stock Location <u>40</u> Memo	0.00 0.00							10/11/4 SP (200)
150  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/11/05 MF 10-11-4

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 3:58:44 PM

Page 1

Work Order ID: 62724

Parent Item: D3200-1

Parent Item Name: Door Post Block





Start Date: 10/6/2010

Required Date: 11/1/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			100	sf	164.0533	0.05	1.052632			
UHMW 1" Black													

Location

Loc Qty

Loc Code

MAT

164.0533

113903

79.7473

✓114624

8.8

115325

75.506

1.0526 sf

A.A 10/11/01

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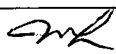
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	62724
Description: Door Post Block		Part Number:	D3200-1
Inspection Dwg: D3200	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005 -0.000	Ø0.199	✓		Vern	6A -01
0.405 x 100°	+/-0.010	0.408x100°	✓		"	"
R0.100	+/-0.010	R 0.100	✓		R.G	ref.
R0.130	+/-0.010	R 0.125	✓		"	"
1.630	+/-0.005	1.630	✓		Vern	6A-01
0.440	+/-0.030	0.436	✓		"	"
2.500	+/-0.010	2.502	✓		"	"
1.845	+/-0.010	1.844	✓		"	"
0.015 - 0.050	N/A	0.025	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
1.620	+/-0.005	1.620	✓		"	"
2.500	+/-0.030	2.503	✓		"	"
0.750	+/-0.030	0.753	✓		"	"

Measured by: B.A	Audited by: 	Prototype Approval:	N/A
Date: 10/11/02	Date: 10/11/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D412-698-015	KJ/RF 	

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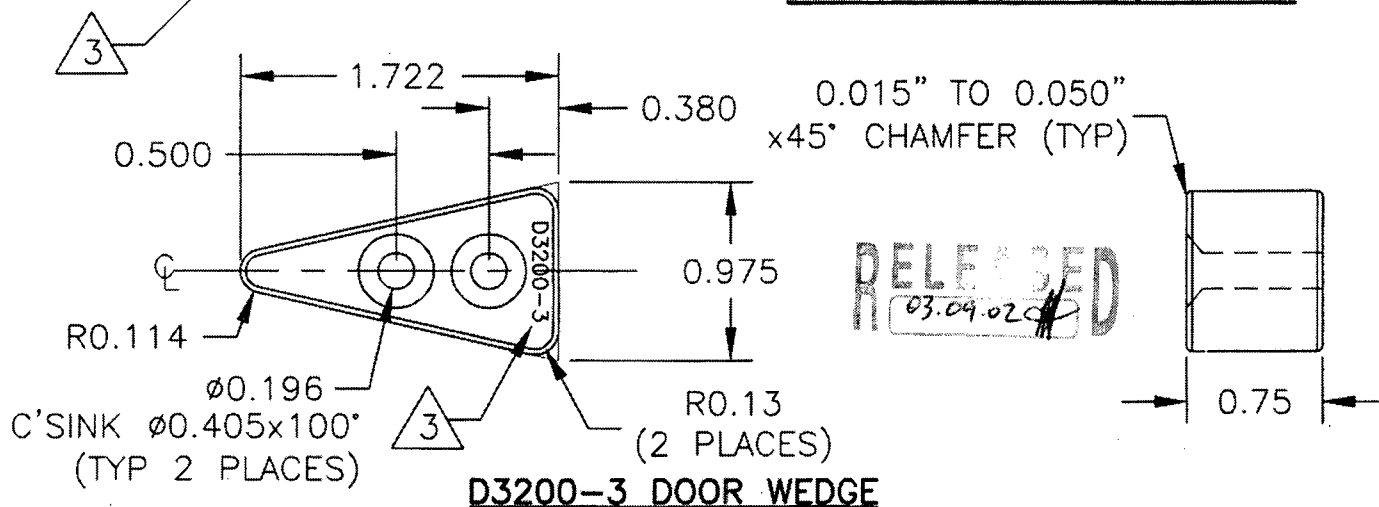
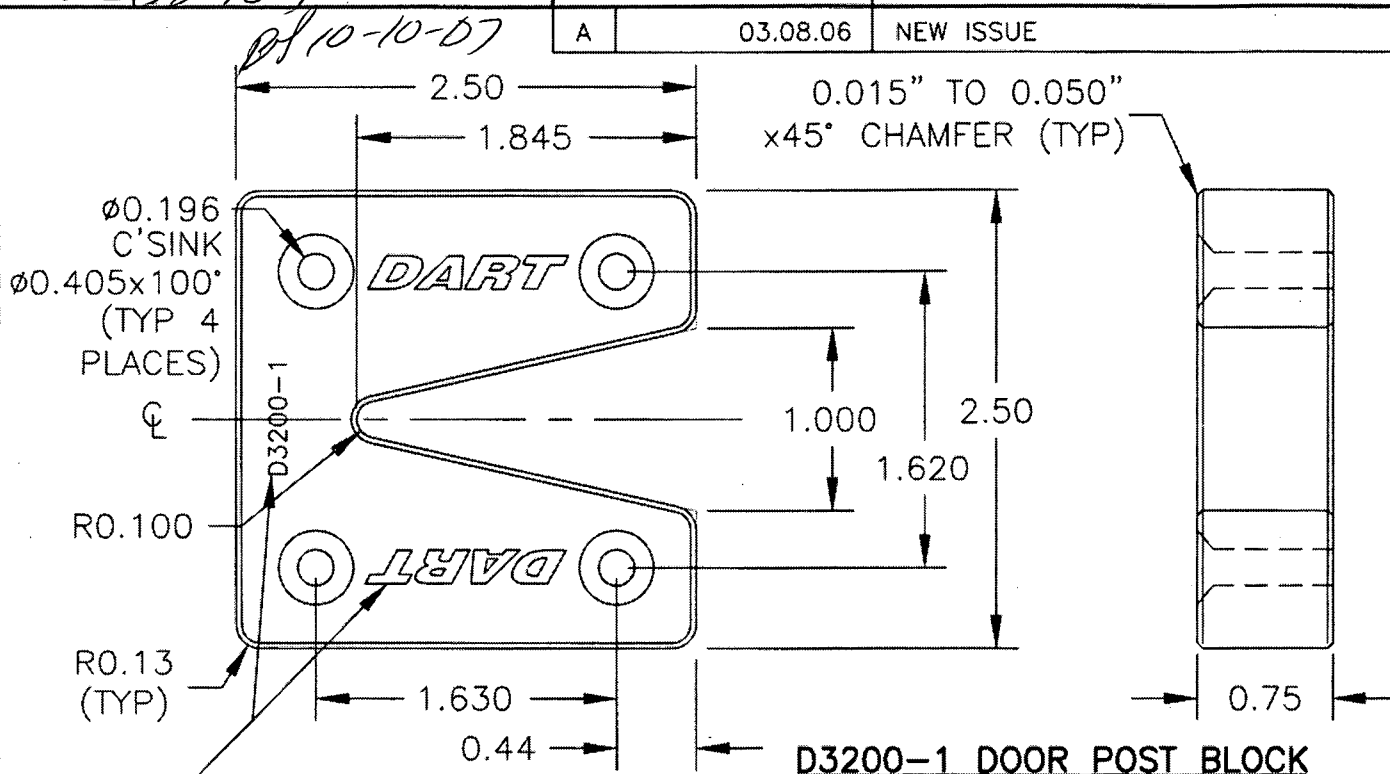
UNCO
SUBJ

DART



NO. 62724

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06	TITLE DOOR WEDGE		SCALE 1:1
A	03.08.06	NEW ISSUE	



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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